

Date: Wednesday, 9/20/2006 3:16:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: A119 STEP WELDMENT RH
Job Number	: 28655		
Estimate Number	: 10130		
P.O. Number	: N/A	Part Number	: D3043042
This Issue	: 9/20/2006 S.O. No. : N/A	Drawing Number	: D3043 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 26198A	Material	: N/A
Written By	: <u> </u>	Due Date	: 9/25/2006 Qty: 1 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est Rev :A New Issue JLM 05-11-01		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: D2622-120C extrusion

Batch: B27077P.E. 06.09.21

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

2-Deburr and bevel ends for welding

327077P.E. 06.09.21P.E. 06.09.21

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

PD 06-09-21 (1)

4.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap

B27281P.E. 06.09.21

5.0	D30401	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-1 Mounting Lug

B24405P.E. 06.09.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/20/2006 3:16:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 28655

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug B24406

PE. 06.09.21 /

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808

AR AL ROD Batch: m19612 m15689

PE. 06.09.21 /

2-Grind Fwd End Cap weld flush

PE. 06.09.21 /

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PE 06-09-21 (1)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FF 06.09.21 /

CE
~~2-Powder Coat White (Ref 4.3.5.2) as per QSI 005 4.3~~

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch: m15689

2-Inspect for foreign object as per QSI 024

3-Grind Fwd End Cap weld flush

PE. 06.09.22 /

PE. 06.09.22 /

PE. 06.09.22 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/20/2006 3:16:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 28655

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/09/22 ①

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

FC 06 09 22 ①

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 09 22 ①

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

06-09-23 ①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/06/09/20 ①

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11/06/09/25 ①

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11/06/09/25

Job Completion



Cold 10/9/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *[Signature]*

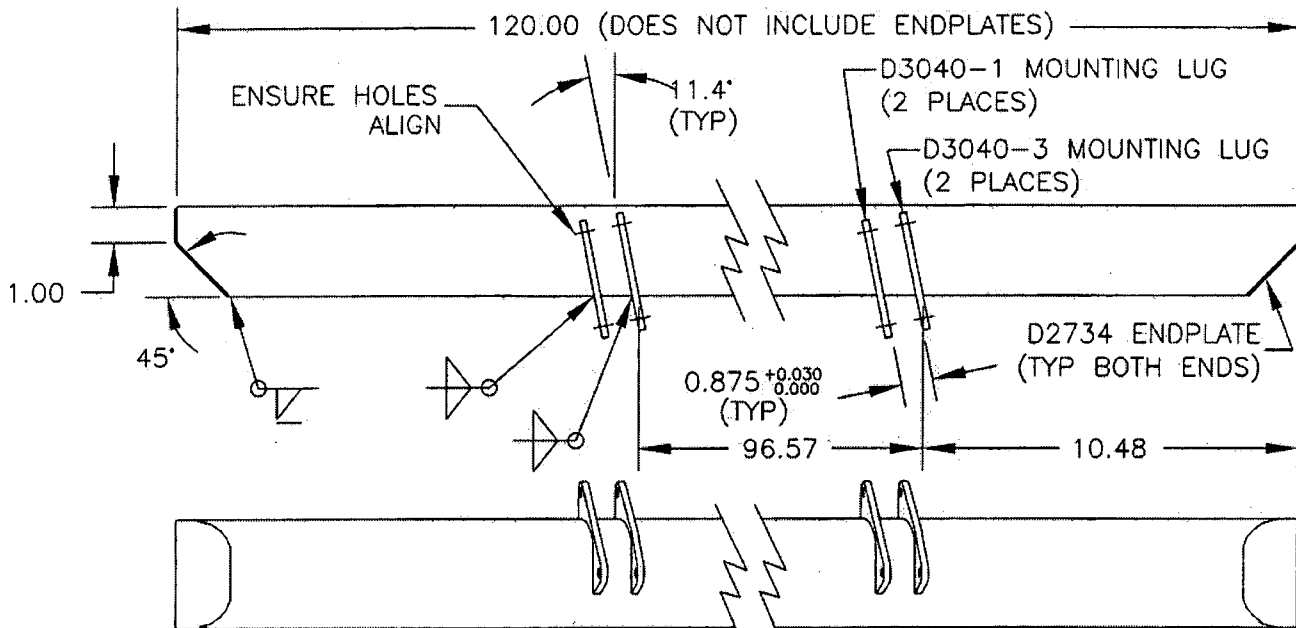
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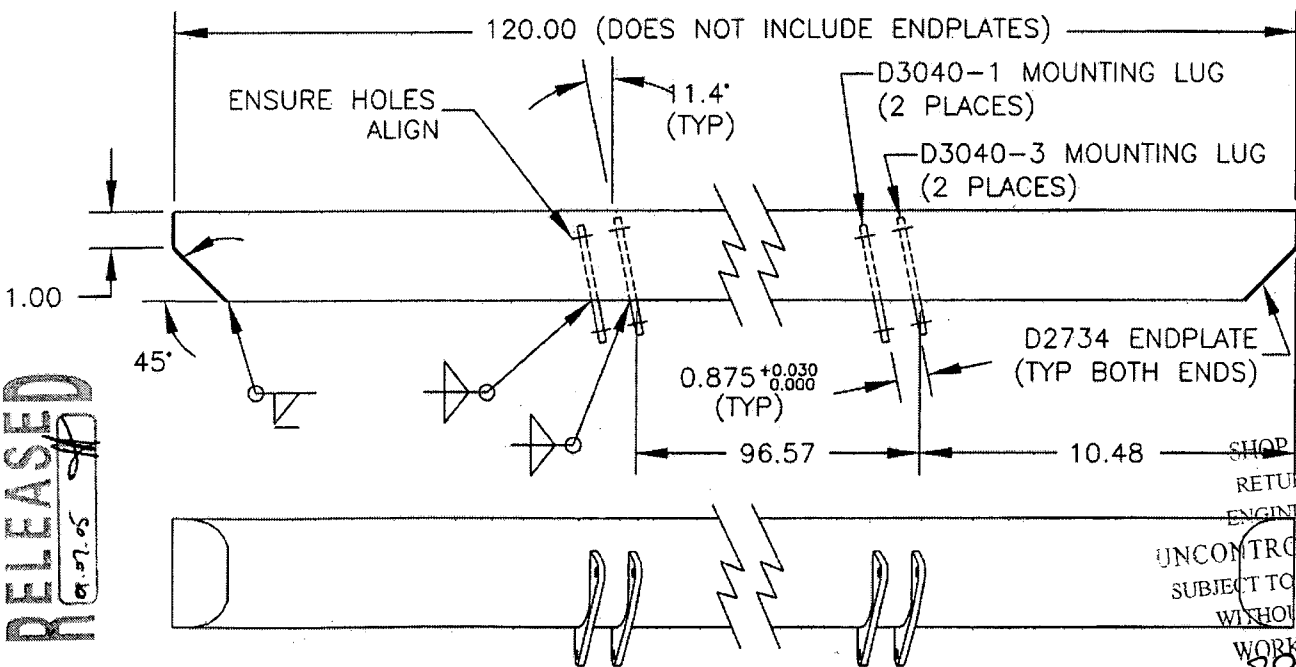
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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